

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013344**Date Inspected:** 22-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhou Cheng/Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Bay#08

During random in process inspection at OBG fabrication bay 8, This QA inspector observed that ZPMC personal prepare a bevel of the bike path deck plate splices. The bike path is identified as BK004A and the component is deck plate splice BK PL1A and BKPL2A. This QA inspector observed that all the components of bike path are stored in that bay. ZPMC personal starts fabricate the bike path BK004A in this OBG fabrication bay 8.

For further information, please see attached pictures.

Bay#19

During random in process inspection of bottom plate BP026-013, this QA inspector observed that ZPMC personal performing weld repair. Weld repair was performed by SMAW welding process. The welds were rejected in UT after heat straightening of the bottom plate splices. These welds were UT accepted before heat straightening. ZPMC UT technician found total four (4) UT reject location after heat straightening. The welds and weld repair reports (WRR) are identified as:

BP026-013-001 - BWR11229, One (1) UT reject location.

BP026-013-003 - BWR11230, Three (3) UT reject locations.

Welder is identified as 062772 (1G). ZPMC QC is identified as Zhou Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-1G(1F)-FCM-Repair.

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Bay#14

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(Seg3001A-007)

Bay#14

FCAW welding of weld joint DP3052-PP113-137, 157 located on Segment 12BW. Welder is identified as 204730 (3G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U4b-F.

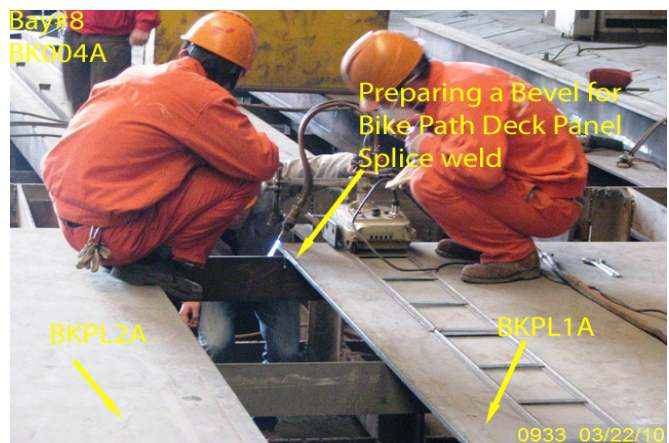
FCAW welding of weld joint DP3051-PP113-105, 120 located on Segment 12BW. Welder is identified as 204730 (3G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U4b-F.

SAW welding of weld joint Seg3005*-005 located on Segment 12BW. Welder is identified as 045265 (1G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2.

FCAW welding of weld joint Seg3006M-021 located on Segment 12CW. Welder is identified as 202122 (3G). ZPMC QC is identified as Tao Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-B-U2-F.

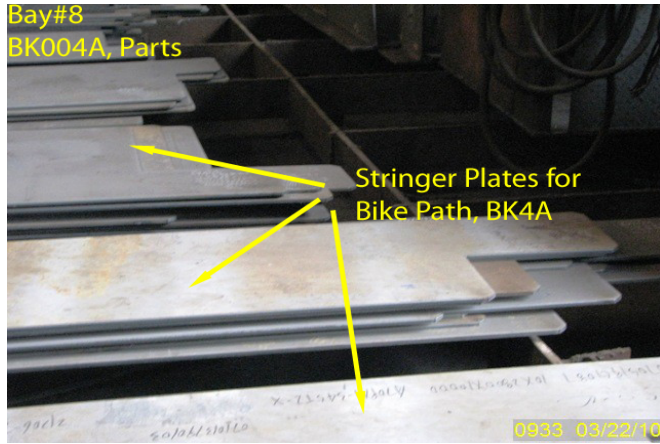
FCAW welding of weld joint Seg3006N-138 located on Segment 12CW. Welder is identified as 201215 (3G). ZPMC QC is identified as Tao Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-B-U2-F.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
